

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 132868

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132868

Page 2

Item ID: D119-827-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Tail Rotor Pedal Lockout

Stop ***NS2***

Start Date: 5/13/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/13/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-827-011								
	Location: _____ <i>Ship</i>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

*DAS
6
9-89**JUN 15 2015**MLJ**JUN 15 2015**MF
15-6-15*

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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														

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Page 1

Work Order ID: 132868

132868

Parent Item: D119-827-011

D119-827-011

Parent Item Name: Tail Rotor Pedal Lockout

Start Date: 5/13/2015

Required Date: 5/13/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP
REV:B 13-01-09 REV B JLM VERIFIED:DD IPP REV:C
12.10.16 as per CHG002 (ecn 13-538) DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4704-041		Manufactured	No			110	Each	0.0000	1	1		DAS 27 9-89	DAS 26 9-89
D4704-041 Expandable Pin Assembly	DAS 02 9-89							B129966	**				
D4703-041		Manufactured	No			110	Each	8.0000	2	2		DAS 27 9-89	DAS 26 9-89
D4703-041 Lock Pin Assembly	DAS 02 9-89								**				
				<u>Location</u>				<u>Loc Qty</u>					
				ST123				8					
				127873				8		2			
D4710-1		Manufactured	No			110	Each	10.0000	1	1		DAS 27 9-89	DAS 26 9-89
D4710-1 Spacer	DAS 02 9-89								**				
				<u>Location</u>				<u>Loc Qty</u>					
				ST123				10					
				127249				10		1			
D4721-1		Manufactured	No			110	Each	7.0000	1	1		DAS 27 9-89	DAS 26 9-89
D4721-1 Decal	DAS 02 9-89								**				
				<u>Location</u>				<u>Loc Qty</u>					
				ST121				5					
				127250				5		1			
				ST124				2					
				121659				2					

JUN 15 2015

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
Root Cause				FAULT CATEGORY																					
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OTHER : _____																									

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Work Order ID: 132868

132868

Parent Item: D119-827-011

D119-827-011

Parent Item Name: Tail Rotor Pedal Lockout

Start Date: 5/13/2015

Required Date: 5/13/2015

Start Qty: 1.00

Required Qty: 1.00

AN4-11A

Purchased

No

110

Each

231.0000

2

2

AN4-11A

BOLT

DAS
02
9-89

**

DAS
27
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

20

120731

20

ST325A

211

11921

1

M128362

209

M128769

1

MS14144L4

Purchased

No

110

Each

5.0000

2

2

MS14144L4

Nut

DAS
02
9-89

**

DAS
27
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

ST316

5

m131224

5

MS24665-153

Purchased

No

110

Each

85.0000

2

2

MS24665-153

Cotter Pin

DAS
02
9-89

**

DAS
27
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

ST294

85

107139

85

NAS1149D0416J

Purchased

No

110

Each

4,886.000

2

2

NAS1149D0416J

WASHER

DAS
02
9-89

**

DAS
27
9-89
JUN 15 2015
DAS
26
9-89

Location

Loc Qty

Loc Code

ST270

4886

m131511

4886

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Work Order ID: 132868

132868

Parent Item: D119-827-011

D119-827-011

Parent Item Name: Tail Rotor Pedal Lockout

Start Date: 5/13/2015

Required Date: 5/13/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

4,333.000

8

8

NAS1149D0463J

WASHER

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST269

4292

M129682

86

M130799

371

M132035

3835

**

DAS
27
9-89

DAS
28
9-89

NAS6604D16

Purchased

No

110

Each

47.0000

2

2

NAS6604D16

Bolt

DAS
02
9-89

Location

Loc Qty

Loc Code

ST262

47

m131616

47

**

DAS
27
9-89

DAS
28
9-89

JUN 15 2015

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OTHER : _____					

4.0 PARTS LIST

-011	Part Number	Description
X	D119-827-011	TAIL ROTOR PEDAL LOCKOUT
1	D4704-041	EXPANDABLE PIN ASSY
2	D4703-041	LOCKOUT PIN ASSY
1	D4710-1	SPACER
1	D4721-1	DECAL
2	AN4-11A	BOLT
2	MS14144L4	NUT
2	MS24665-153	COTTER PIN
2	NAS1149D0416J	WASHER
8	NAS1149D0463J	WASHER
2	NAS6604D16	BOLT

5.0 WEIGHT AND BALANCE

The following are the net weight increases associated with D119-827-011 kit.

Installation	Weight	Longitudinal		Lateral	
		Arm	Moment	Arm	Moment
D119-827-011 ON A109/A119 MODELS	0.52 lb 0.23 kg	32.6 in 0.83 m	16.9 in-lb 0.19 m-kg	-13.1 in -0.33 m	-6.8 in-lb -0.08 m-kg
D119-827-011 ON 206/407 MODELS	0.52 lb 0.23 kg	33.0 in 0.84 m	17.2 in-lb 0.19 m-kg	-12.5 in -0.32 m	-6.5 in-lb -0.07 m-kg